

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of:)
Renato CARETTA)
Serial No.: Not yet assigned) Group Art Unit: Not yet assigned
Filed: April 27, 2001) Examiner: Not yet assigned
For: CARCASS STRUCTURE FOR)
VEHICLE-WHEEL TYRES AND ITS)
METHOD OF MANUFACTURING)

Assistant Commissioner for Patents
Washington, DC 20231

Sir:

PRELIMINARY AMENDMENT

Prior to the examination of the above-captioned application, please amend this
application as follows:

IN THE SPECIFICATION:

Please amend the specification, as follows:

Add two section headings, a section subheading, and a paragraph immediately after the
title CARCASS STRUCTURE FOR VEHICLE-WHEEL TYRES AND ITS METHOD OF
MANUFACTURING, as follows:

--CROSS-REFERENCES TO RELATED APPLICATIONS

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FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
202-408-4000

This application is a continuation of International Patent Application No. PCT/EP99/07963, filed October 20, 1999, in the European Patent Office; additionally, Applicants claim the right of priority under 35 U.S.C. § 119(a) - (d) based on patent application No. 98830661.9, filed October 30, 1998, in the European Patent Office; further, Applicants claim the benefit under 35 U.S.C. § 119(e) based on prior-filed, copending provisional application No. 60/114,157, filed December 29, 1998, in the U.S. Patent and Trademark Office; the contents of all of which are relied upon and incorporated herein by reference.

BACKGROUND OF THE INVENTION

Field of the Invention--

Page 1, line 27, add section subheading --Description of the Related Art-- prior to the start of the paragraph beginning "Manufacturing of tyres for vehicle wheels"

Page 5, line 4, add section heading --SUMMARY OF THE INVENTION-- prior to the start of the paragraph beginning "In accordance with the present invention"

Page 10, line 21, add section heading --BRIEF DESCRIPTION OF THE DRAWINGS-- prior to the start of the paragraph beginning "Further features and advantages. . . ."

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& DUNNER, L.L.P.
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Page 11, line 34, add section heading --DETAILED DESCRIPTION OF THE
PREFERRED EMBODIMENTS-- prior to the start of the paragraph beginning "With reference
to the drawings"

Add a new Page 39 after the claims, adding the following ABSTRACT OF THE
DISCLOSURE. A new, separate Page 39 is enclosed.

--ABSTRACT OF THE DISCLOSURE

A carcass structure for a vehicle wheel tyre includes at least one carcass ply comprising thread elements substantially disposed transversely of a circumferential extension of the carcass structure, and at least one pair of annular reinforcing structures disposed close to respective inner circumferential edges of the at least one carcass ply. Each of the annular reinforcing structures includes at least one first circumferentially-inextensible annular insert formed of at least one first elongated element extending in concentric coils, and at least one second circumferentially-inextensible annular insert formed of at least one second elongated element extending in concentric coils. The at least one carcass ply has end flaps each turned back around an inner circumferential edge of a respective first annular insert and each axially interposed between respective first and second annular inserts. A method of manufacturing the carcass structure is also disclosed.--

IN THE CLAIMS:

Please amend claims 1-29 and add new claims 30-58, as follows:

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& DUNNER, L.L.P.
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1. (once amended) A carcass structure for a vehicle wheel tyre, comprising:
at least one carcass ply comprising thread elements substantially disposed transversely of a circumferential extension of the carcass structure; and
at least one pair of annular reinforcing structures disposed close to respective inner circumferential edges of the at least one carcass ply, each of the annular reinforcing structures comprising:
at least one first circumferentially-inextensible annular insert substantially in a form of a crown disposed substantially coaxially of the carcass structure, close to an inner circumferential edge of the at least one carcass ply, the at least one first annular insert being formed of at least one first elongated element extending in concentric coils; and
at least one second circumferentially-inextensible annular insert substantially in a form of a crown disposed coaxially of the tyre, the at least one second annular insert being formed of at least one second elongated element extending in concentric coils,
wherein the at least one carcass ply has end flaps each turned back around an inner circumferential edge of a respective first annular insert and each axially interposed between respective first and second annular inserts,
the at least one carcass ply and each first annular insert abutting against each other along either a whole surface extension of the at least one first annular insert or a whole radial extension of the end flaps.

2. (once amended) The carcass structure of claim 1, further comprising at least one filling body of elastomer material in contact with at least one of the annular inserts.

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& DUNNER, L.L.P.
1300 I STREET, N. W.
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3. (once amended) The carcass structure of claim 2, wherein the at least one second annular insert is interposed between a respective end flap and the at least one filling body, the at least one second annular insert being in contact with an end flap on an opposite side relative to the at least one first annular insert.

4. (once amended) The carcass structure of claim 1, wherein a respective end flap of the at least one carcass ply completely covers a respective first annular insert.

5. (once amended) The carcass structure of claim 1, wherein the at least one second annular insert projects beyond one end region of a respective end flap.

6. (once amended) The carcass structure of claim 1, wherein each second annular insert projects beyond an outer circumferential edge of the at least one first annular insert.

7. (once amended) The carcass structure of claim 1, wherein the at least one first annular insert comprises at least one first series of concentric coaxial coils and at least one second series of concentric coaxial coils disposed in axial side-by-side relationship with the coils of the at least one first series.

8. (once amended) The carcass structure of claim 7, wherein a number of coils of the at least one first series is greater than a number of coils of the at least one second series.

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9. (once amended) The carcass structure of claim 8, wherein the at least one first coil series is directly in contact with the at least one carcass ply, whereas the at least one second coil series is directly in contact with a respective end flap.

10. (once amended) The carcass structure of claim 1, wherein the at least one first annular insert projects beyond one end region of a respective end flap.

11. (once amended) The carcass structure of claim 1, wherein the at least one first annular insert projects beyond an outer circumferential edge of a respective second annular insert.

12. (once amended) The carcass structure of claim 2, wherein the at least one filling body is interposed between a respective end flap of the at least one carcass ply and a respective second annular insert.

13. (once amended) The carcass structure of claim 12, wherein the at least one second annular insert is directly in contact with at least one axially outer side surface of a respective filling body, located on an opposite side relative to an end flap of the at least one carcass ply.

14. (once amended) The carcass structure of claim 2, wherein the at least one filling body has a circumferentially outer portion directly in contact with a side surface of the at least one carcass ply.

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15. (once amended) The carcass structure of claim 1, wherein the at least one carcass ply comprises:

a plurality of strip sections each comprising at least two of the thread elements disposed longitudinally and parallel to each other and at least partly covered with at least one layer of raw elastomer material,

each of the strip sections extending in a substantially U-shaped configuration according to a cross section outline of the carcass structure, to define two side portions substantially extending in planes orthogonal to a geometric axis of the carcass structure at mutually spaced apart positions in an axial direction, and a crown portion extending at a radially outer position between the side portions,

the crown portions being disposed in side-by-side relationship with each other along the circumferential extension of the carcass structure, whereas the side portions of each strip section are each partly covered with a side portion of at least one adjoining strip section.

16. (once amended) The carcass structure of claim 15, wherein the side portions of the strip sections mutually converge towards the geometric axis of the carcass structure, covering of the side portions of the strip sections progressively increasing in a direction of the inner circumferential edge of the at least one carcass ply, starting from a zero value close to transition regions between the side portions and the crown portions.

17. (once amended) A method of manufacturing a carcass structure for vehicle wheel tyres, comprising the steps of:

making a carcass ply having a pair of end flaps disposed circumferentially internally;

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forming at least one annular reinforcing structure; and

applying the at least one annular reinforcing structure close to each end flap of the carcass ply;

wherein the step of forming the at least one annular reinforcing structure comprises:

applying at least one first circumferentially-inextensible annular insert close to a respective end flap of the carcass ply, the at least one first annular insert being formed of at least one first elongated element disposed in concentric coils;

turning back a respective end flap of the carcass ply around an inner circumferential edge of the at least one first annular insert, causing the carcass ply and at least one first annular insert to be applied against each other according to either a whole surface extension of the at least one first annular insert or a whole radial extension of the end flap; and

applying at least one second circumferentially-inextensible annular insert close to the at least one first annular insert, the second annular insert being formed of at least one second elongated element disposed in concentric coils.

18. (once amended) The method of claim 17, further comprising the step of applying at least one filling body of elastomer material in contact with at least one of the annular inserts.

19. (once amended) The method of claim 17, wherein at least one of the first and second annular inserts is formed by winding up a continuous elongated element in radially-superposed concentric coils.

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20. (once amended) The method of claim 17, wherein at least one of the first and second annular inserts is formed directly against the carcass ply.

21. (once amended) The method of claim 17, wherein at least one of the first and second annular inserts is formed in a forming die, the forming die being subsequently moved against the carcass ply for application of the at least one of the first and second annular inserts.

22. (once amended) The method of claim 17, wherein the turning-back of the respective end flap comprises the following steps:

axially pushing the end flap for moving the end flap from a first position wherein the end flap projects radially inwardly relative to the at least one first annular insert to a second position wherein the end flap is axially oriented away from an equatorial plane of the carcass structure; and

exerting a rolling action on the end flap for laterally applying the end flap against the at least one first annular insert.

23. (once amended) The method of claim 18, wherein application of the at least one filling body comprises the steps of:

making the at least one filling body in a forming die; and
axially moving the forming die against the carcass structure.

24. (once amended) The method of claim 23, further comprising a step of coupling the at least one filling body with the at least one second annular insert in the forming die, before

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& DUNNER, L.L.P.
1300 I STREET, N. W.
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simultaneous application of the at least one filling body and the at least one second annular insert against the carcass structure.

25. (once amended) The method of claim 17, wherein application of the at least one filling body is carried out by forming the at least one filling body directly against the carcass structure.

26. (once amended) The method of claim 25, wherein the forming of the at least one filling body against the carcass structure takes place by extrusion of at least one continuous strip element wound up in superposed coils.

27. (once amended) The method of claim 17, wherein manufacturing of the carcass ply comprises the following steps:

preparing strip sections each comprising longitudinal and parallel thread elements at least partly coated with one layer of raw elastomer material; and

depositing each of the strip sections onto a toroidal support in a substantially U-shaped conformation around a cross section outline of the toroidal support, to define two side portions substantially extending in planes orthogonal to a geometric axis of rotation of the toroidal support at mutually spaced apart positions in an axial direction, and a crown portion extending at a radially outer position between the side portions,

wherein the crown portions of each strip section are consecutively disposed in side-by-side relationship along a circumferential extension of the toroidal support, whereas the side

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portions of each strip section are each partly covered with a side portion of at least one circumferentially consecutive section.

28. (once amended) The method of claim 27, wherein the side portions belonging to circumferentially contiguous strip sections on the toroidal support are caused to mutually converge in a direction of the geometric rotation axis of the toroidal support, covering of the side portions of each strip section progressively increasing in a direction of an inner circumferential edge of the carcass ply starting from a zero value close to transition regions between the side portions and the crown portions.

29. (once amended) The method of claim 27, wherein the strip sections are laid down by making the side portions of each strip section project from an inner circumferential edge of the toroidal support, projecting ends of the side portions defining the end flaps of the carcass ply.

Please add new claims 30-58, as follows:

30. (new) A carcass structure for a vehicle wheel tyre, comprising:

at least one carcass ply comprising thread elements substantially disposed transversely of a circumferential extension of the carcass structure; and

at least one pair of annular reinforcing structures disposed close to respective inner circumferential edges of the at least one carcass ply, each of the annular reinforcing structures comprising:

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at least one first circumferentially-inextensible annular insert substantially in a form of a crown disposed substantially coaxially of the carcass structure, close to an inner circumferential edge of the at least one carcass ply, the at least one first annular insert being formed of at least one first elongated element extending in concentric coils; and

at least one second circumferentially-inextensible annular insert substantially in a form of a crown disposed coaxially of the tyre, the at least one second annular insert being formed of at least one second elongated element extending in concentric coils,

wherein the at least one carcass ply has end flaps each turned back around an inner circumferential edge of a respective first annular insert and each axially interposed between respective first and second annular inserts,

each of the first and second annular inserts exhibiting a radially elongated transverse section outline.

31. (new) The carcass structure of claim 30, further comprising at least one filling body of elastomer material in contact with at least one of the annular inserts.

32. (new) The carcass structure of claim 31, wherein the at least one second annular insert is interposed between a respective end flap and the at least one filling body, the at least one second annular insert being in contact with an end flap on an opposite side relative to the at least one first annular insert.

33. (new) The carcass structure of claim 30, wherein a respective end flap of the at least one carcass ply completely covers a respective first annular insert.

34. (new) The carcass structure of claim 30, wherein the at least one second annular insert projects beyond one end region of a respective end flap.

35. (new) The carcass structure of claim 30, wherein each second annular insert projects beyond an outer circumferential edge of the at least one first annular insert.

36. (new) The carcass structure of claim 30, wherein the at least one first annular insert comprises at least one first series of concentric coaxial coils and at least one second series of concentric coaxial coils disposed in axial side-by-side relationship with the coils of the at least one first series.

37. (new) The carcass structure of claim 36, wherein a number of coils of the at least one first series is greater than a number of coils of the at least one second series.

38. (new) The carcass structure of claim 37, wherein the at least one first coil series is directly in contact with the at least one carcass ply, whereas the at least one second coil series is directly in contact with a respective end flap.

39. (new) The carcass structure of claim 30, wherein the at least one first annular insert projects beyond one end region of a respective end flap.

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& DUNNER, L.L.P.
1300 I STREET, N. W.
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40. (new) The carcass structure of claim 30, wherein the at least one first annular insert projects beyond an outer circumferential edge of a respective second annular insert.

41. (new) The carcass structure of claim 31, wherein the at least one filling body is interposed between a respective end flap of the at least one carcass ply and a respective second annular insert.

42. (new) The carcass structure of claim 41, wherein the at least one second annular insert is directly in contact with at least one axially outer side surface of a respective filling body, located on an opposite side relative to an end flap of the at least one carcass ply.

43. (new) The carcass structure of claim 31, wherein the at least one filling body has a circumferentially outer portion directly in contact with a side surface of the at least one carcass ply.

44. (new) The carcass structure of claim 30, wherein the at least one carcass ply comprises:

a plurality of strip sections each comprising at least two of the thread elements disposed longitudinally and parallel to each other and at least partly covered with at least one layer of raw elastomer material,

each of the strip sections extending in a substantially U-shaped configuration according to a cross section outline of the carcass structure, to define two side portions substantially extending in planes orthogonal to a geometric axis of the carcass structure at mutually spaced

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& DUNNER, L.L.P.
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apart positions in an axial direction, and a crown portion extending at a radially outer position between the side portions,

the crown portions being disposed in side-by-side relationship with each other along the circumferential extension of the carcass structure, whereas the side portions of each strip section are each partly covered with a side portion of at least one adjoining strip section.

45. (new) The carcass structure of claim 44, wherein the side portions of the strip sections mutually converge towards the geometric axis of the carcass structure, covering of the side portions of the strip sections progressively increasing in a direction of the inner circumferential edge of the at least one carcass ply, starting from a zero value close to transition regions between the side portions and the crown portions.

46. (new) A method of manufacturing a carcass structure for vehicle wheel tyres, comprising the steps of:

making a carcass ply having a pair of end flaps disposed circumferentially internally;

forming at least one annular reinforcing structure; and

applying the at least one annular reinforcing structure close to each end flap of the carcass ply;

wherein the step of forming the at least one annular reinforcing structure comprises:

applying at least one first circumferentially-inextensible annular insert close to a respective end flap of the carcass ply, the at least one first annular insert being formed of at least one first elongated element disposed in concentric coils;

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turning back a respective end flap of the carcass ply around an inner circumferential edge of the at least one first annular insert, and

applying at least one second circumferentially-inextensible annular insert close to the at least one first annular insert, the second annular insert being formed of at least one second elongated element disposed in concentric coils,

each of the first and second annular inserts being formed according to a radially elongated transverse section outline.

47. (new) The method of claim 46, further comprising the step of applying at least one filling body of elastomer material in contact with at least one of the annular inserts.

48. (new) The method of claim 46, wherein at least one of the first and second annular inserts is formed by winding up a continuous elongated element in radially-superposed concentric coils.

49. (new) The method of claim 46, wherein at least one of the first and second annular inserts is formed directly against the carcass ply.

50. (new) The method of claim 46, wherein at least one of the first and second annular inserts is formed in a forming die, the forming die being subsequently moved against the carcass ply for application of the at least one of the first and second annular inserts.

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51. (new) The method of claim 46, wherein the turning-back of the respective end flap comprises the following steps:

axially pushing the end flap for moving the end flap from a first position wherein the end flap projects radially inwardly relative to the at least one first annular insert to a second position wherein the end flap is axially oriented away from an equatorial plane of the carcass structure; and

exerting a rolling action on the end flap for laterally applying the end flap against the at least one first annular insert.

52. (new) The method of claim 47, wherein application of the at least one filling body comprises the steps of:

making the at least one filling body in a forming die; and

axially moving the forming die against the carcass structure.

53. (new) The method of claim 52, further comprising a step of coupling the at least one filling body with the at least one second annular insert in the forming die, before simultaneous application of the at least one filling body and the at least one second annular insert against the carcass structure.

54. (new) The method of claim 46, wherein application of the at least one filling body is carried out by forming the at least one filling body directly against the carcass structure.

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55. (new) The method of claim 54, wherein the forming of the at least one filling body against the carcass structure takes place by extrusion of at least one continuous strip element wound up in superposed coils.

56. (new) The method of claim 46, wherein manufacturing of the carcass ply comprises the following steps:

preparing strip sections each comprising longitudinal and parallel thread elements at least partly coated with one layer of raw elastomer material; and

depositing each of the strip sections onto a toroidal support in a substantially U-shaped conformation around a cross section outline of the toroidal support, to define two side portions substantially extending in planes orthogonal to a geometric axis of rotation of the toroidal support at mutually spaced apart positions in an axial direction, and a crown portion extending at a radially outer position between the side portions,

wherein the crown portions of each strip section are consecutively disposed in side-by-side relationship along a circumferential extension of the toroidal support, whereas the side portions of each strip section are each partly covered with a side portion of at least one circumferentially consecutive section.

57. (new) The method of claim 56, wherein the side portions belonging to circumferentially contiguous strip sections on the toroidal support are caused to mutually converge in a direction of the geometric rotation axis of the toroidal support, covering of the side portions of each strip section progressively increasing in a direction of an inner circumferential

edge of the carcass ply starting from a zero value close to transition regions between the side portions and the crown portions.

58. (new) The method of claim 56, wherein the strip sections are laid down by making the side portions of each strip section project from an inner circumferential edge of the toroidal support, projecting ends of the side portions defining the end flaps of the carcass ply.

REMARKS

Applicant submits this Preliminary Amendment together with a continuation application under 37 C.F.R. § 1.53(b). Claims 1-58 are pending in this application.

In this Amendment, Applicant adds section headings, section subheadings, and an Abstract of the Disclosure to conform to U.S. practice. Additionally, Applicant amends claims 1-29, which include the same subject matter as the original claims, to improve clarity. Further, Applicant adds new claims 30-58. The originally-filed specification, claims, abstract, and drawings fully support the amendments to the specification and claims, and the added claims. No new matter was introduced.

If there is any fee due in connection with the filing of this Preliminary Amendment, please charge the fee to our Deposit Account No. 06-0916.

Respectfully submitted,

FINNEGAN, HENDERSON, FARABOW,
GARRETT & DUNNER, L.L.P.

By: 

Lawrence F. Galvin
Reg. No. 44,694

Dated: April 27, 2001

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FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
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APPENDIX TO PRELIMINARY AMENDMENT DATED APRIL 27, 2001

Amendments to the Claims

Please amend claims 1-29, as follows:

1. (once amended) A carcass structure for a vehicle wheel tyre[s], comprising:

[-] at least one carcass ply [(3)] comprising thread[-like] elements [(14)] substantially disposed transversely of a circumferential extension of the carcass structure [(2)]; and

[-] at least one pair of annular reinforcing structures [(4)] disposed close to respective inner circumferential edges of the at least one carcass ply [(3)], each of [said] the annular reinforcing structures [(4)] comprising:

[-] at least one first circumferentially-inextensible annular insert [(26)] substantially in [the] a form of a crown disposed substantially coaxially of the carcass structure [(2)], close to an inner circumferential edge of the at least one carcass ply [(3)], [said] the at least one first annular insert [(26)] being formed of at least one first elongated element extending in concentric coils [(26a, 26b)]; and

[-] at least one second circumferentially-inextensible annular insert [(30)] substantially in [the] a form of a crown disposed coaxially of the tyre, [said] the at least one second annular insert [(30)] being formed of at least one second elongated element extending in concentric coils [(30a)],

[characterized in that said] wherein the at least one carcass ply [(3)] has end flaps [(25a)] each turned back around an inner circumferential edge of [the] a respective first annular insert [(26)] and each axially interposed between [the] respective first and second annular inserts [(26, 30)],

the at least one carcass ply and each first annular insert abutting against each other along either a whole surface extension of the at least one first annular insert or a whole radial extension of the end flaps.

2. (once amended) [A] The carcass structure [as claimed in] of claim 1, further comprising at least one filling body [(31)] of elastomer material in contact with at least one of [said] the [inextensible] annular inserts [(26, 30)].

3. (once amended) [A] The carcass structure [as claimed in] of claim 2, wherein the at least one second [inextensible] annular insert [(30)] is interposed between [the] a respective end flap [(25a)] and the at least one filling body [(31)], [said] the at least one second [inextensible] annular insert [(30)] being in contact with [the] an end flap [(25a)] on [the] an opposite side relative to the at least one first [inextensible] annular insert [(26)].

4. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein [the] a respective end flap [(25a)] of the at least one carcass ply [(3)] completely covers [the] a respective first [inextensible] annular insert [(26)].

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& DUNNER, L.L.P.
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5. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein the at least one second [inextensible] annular insert [(30)] projects beyond one end region of [the] a respective end flap [(25a)].

6. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein each second [inextensible] annular insert [(30)] projects beyond an outer circumferential edge of the at least one first [inextensible] annular insert [(26)].

7. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein the at least one first [inextensible] annular insert [(26)] comprises at least one first series of concentric coaxial coils [(26a)] and at least one second series of concentric coaxial coils [(26b)] disposed in axial side-by-side relationship with the coils [(26a)] of the at least one first series.

8. (once amended) [A] The carcass structure [as claimed in] of claim 7, wherein [the] a number of coils [(26a)] of the at least one first series is greater than [the] a number of coils [(26b)] of the at least one second series.

9. (once amended) [A] The carcass structure [as claimed in] of claim 8, wherein [said] the at least one first coil series [(26a)] is directly in contact with the at least one carcass ply [(3)], whereas the at least one second coil series [(26b)] is directly in contact with [the] a respective end flap.

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FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
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10. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein the at least one first [inextensible] annular insert [(26)] projects beyond one end region of [the] a respective end flap [(25a)].

11. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein the at least one first [inextensible] annular insert [(26)] projects beyond an outer circumferential edge of [the] a respective second [inextensible] annular insert [(30)].

12. (once amended) [A] The carcass structure [as claimed in] of claim 2, wherein the at least one filling body [(31)] is interposed between [the] a respective end flap [(25a)] of the at least one carcass ply [(3)] and [the] a respective second annular insert [(30)].

13. (once amended) [A] The carcass structure [as claimed in] of claim 12, wherein the at least one second annular insert [(30)] is directly in contact with at least one axially outer side surface of [the] a respective filling body [(31)], located on [the] an opposite side relative to [the] an end flap [(25a)] of the at least one carcass ply [(3)].

14. (once amended) [A] The carcass structure [as claimed in claim 1] of claim 2, wherein the at least one filling body [(31)] has a circumferentially outer portion directly in contact with a side surface of the at least one carcass ply [(3)].

15. (once amended) [A] The carcass structure [as claimed in] of claim 1, wherein [said] the at least one carcass ply [(3)] comprises:

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FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
202-408-4000

[-] a plurality of strip[-like] sections [(13)] each comprising at least two of [said] the thread[-like] elements [(14)] disposed longitudinally and [parallelly of] parallel to each other and at least partly covered with at least one layer of raw elastomer material [(17)],

[-] each of [said] the strip[-like] sections [(13)] extending in a substantially U-shaped configuration according to a cross section outline of the carcass structure [(2)], to define two side portions [(25)] substantially extending in planes orthogonal to a geometric axis of the carcass structure [itself] at mutually spaced apart positions in an axial direction, and a crown portion [(24)] extending at a radially outer position between the side portions [(25)];

[- said] the crown portions [(24)] being disposed in side-by-side relationship with each other along the circumferential extension of the carcass structure [(2)], whereas the side portions [(25)] of each strip[-like] section [(13)] are each partly covered with a side portion [(25)] of at least one adjoining strip[-like] section [(13)].

16. (once amended) [A] The carcass structure [as claimed in] of claim 15, wherein the side portions [(25)] of [said] the strip[-like] sections [(13)] mutually converge towards the geometric axis of the carcass structure [(2)], [the] covering of the side portions [(25)] of the strip[-like] sections [(13)] progressively increasing in [the] a direction of the inner circumferential edge of the at least one carcass ply [(3)], starting from a zero value close to transition regions between [said] the side portions [(25)] and [said] the crown portions [(24)].

17. (once amended) A method of manufacturing a carcass structure for vehicle wheel tyres, comprising the steps of:

[-] making a carcass ply [(3)] having a pair of end flaps [(25a)] disposed circumferentially internally;

forming at least one annular reinforcing structure; and

[-] applying the at least one annular reinforcing structure [(4)] close to each end flap [(25a)] of the carcass ply [(3)];

[characterized in that] wherein the step of forming the at least one [each] annular reinforcing structure [(4) is formed by the following steps] comprises:

[-] applying at least one first circumferentially-inextensible annular insert [(26)] close to [the] a respective end flap [(25a)] of the carcass ply [(3)], [said] the at least one first [inextensible] annular insert [(26)] being formed of at least one first elongated element disposed in concentric coils [(26a, 26b)];

[-] turning back [the] a respective end flap [(25a)] of the carcass ply [(3)] around an inner circumferential edge of the at least one first annular insert [(26)], causing the carcass ply and at least one first annular insert to be applied against each other according to either a whole surface extension of the at least one first annular insert or a whole radial extension of the end flap; and

[-] applying at least one second circumferentially-inextensible annular insert [(30)] close to the at least one first annular insert [(26)], [said] the second [inextensible] annular insert [(30)] being formed of at least one second elongated element disposed in concentric coils [(30a)].

18. (once amended) [A] The method [as claimed in] of claim 17, further comprising the step of applying at least one filling body [(31)] of elastomer material in contact with at least one of [said] the annular inserts [(26, 30)].

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FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
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19. (once amended) [A] The method [as claimed in] of claim 17, wherein at least one of [said] the first and second [inextensible] annular inserts [(26, 30)] is formed by winding up a continuous elongated element in radially-superposed concentric coils [(26a, 26b, 30a)].

20. (once amended) [A] The method [as claimed in] of claim 17, wherein at least one of [said] the first and second [inextensible] annular inserts [(26, 30)] is formed directly against the carcass ply [(3)].

21. (once amended) [A] The method [as claimed in] of claim 17, wherein at least one of [said] the first and second annular inserts [(26, 30)] is formed in a forming die [(27)], [said] the forming die [(27)] being subsequently moved against the carcass ply [(3)] for application of the at least one of the first and second [inextensible] annular inserts [(26, 30)].

22. (once amended) [A] The method [as claimed in] of claim 17, wherein [said] the turning-back of the respective end flap [(25a)] comprises the following steps:

[-] axially pushing the end flap [(25a)] for moving [it] the end flap from a first position [in which it] wherein the end flap projects radially inwardly relative to the at least one first [inextensible] annular insert [(26)] to a second position [in which it] wherein the end flap is axially oriented away from an equatorial plane of the carcass structure; and

[-] exerting a rolling action on the end flap [(25a)] for laterally applying [it] the end flap against the at least one first [inextensible] annular insert [(26)].

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& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
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23. (once amended) [A] The method [as claimed in] of claim 18, wherein application of the at least one filling body [(31)] comprises the steps of:

[-] making [said] the at least one filling body [(31)] in a forming die [(32)]; and

[-] axially moving the forming die [(32)] against the carcass structure [(2)].

24. (once amended) [A] The method [as claimed in] of claim 23, further comprising a step of coupling the at least one filling body [(31)] with the at least one second [inextensible] annular insert [(30)] in the forming die [(32)], before [the] simultaneous application of the at least one filling body [(31)] and the at least one second [inextensible] annular insert [(30)] against the carcass structure [(2)].

25. (once amended) [A] The method [as claimed in] of claim 17, wherein application of the at least one filling body [(31)] is carried out by forming the at least one filling body [(31)] directly against the carcass structure [(2)].

26. (once amended) [A] The method [as claimed in] of claim 25, wherein [said] the [formation] forming of the at least one filling body [(31)] against the carcass structure [(2)] takes place by extrusion of at least one continuous strip[-like] element wound up in superposed coils.

27. (once amended) [A] The method [as claimed in] of claim 17, wherein manufacturing of the carcass ply [(3)] comprises the following steps:

[-] preparing strip[-like] sections [(13)] each comprising longitudinal and parallel thread[-like] elements [(14)] at least partly coated with one layer of raw elastomer material [(17)]; and

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FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
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[-] depositing each of the strip[-like] sections [(13)] onto a toroidal support [(11)] in a substantially U-shaped conformation around [the] a cross section outline of the toroidal support, to define two side portions [(25)] substantially extending in planes orthogonal to a geometric axis of rotation of the toroidal support [(11)] at mutually spaced apart positions in an axial direction, and a crown portion [(24)] extending at a radially outer position between the side portions [(25)];₂

[- in which] wherein the crown portions [(24)] of each strip[-like] section [(13)] are consecutively disposed in side-by-side relationship along [the] a circumferential extension of the toroidal support [(11)], whereas the side portions [(25)] of each strip[-like] section [(13)] are each partly covered with a side portion [(25)] of at least one circumferentially consecutive section.

28. (once amended) [A] The method [as claimed in] of claim 27, wherein the side portions [(25)] belonging to circumferentially contiguous strip[-like] sections [(13)] on the toroidal support [(11)] are caused to mutually converge in [the] a direction of the geometric rotation axis of the toroidal support [itself], [the] covering of the side portions [(25)] of each strip[-like] section [(13)] progressively increasing in [the] a direction of [the] an inner circumferential edge of the carcass ply [(3)] starting from a zero value close to transition regions between [said] the side portions [(25)] and [said] the crown portions [(24)].

29. (once amended) [A] The method [as claimed in] of claim 27, wherein the strip[-like] sections [(13)] are laid down by making the side portions [(25)] of each strip[-like] section [(13)]

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FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
202-408-4000

Author	Year	Country	Sample Size	Age Range	Gender	Occupation	Education	Income	Health	Life Satisfaction	Life Expectancy
Smith	1985	USA	1000	18-65	M/F	Student/Worker	High School/College	\$10,000-\$20,000	Good	7.5	75
Johnson	1990	Canada	500	25-70	M/F	Teacher/Manager	University	\$20,000-\$30,000	Very Good	8.2	80
Williams	1995	UK	2000	16-80	M/F	Unemployed/Retired	Primary/Secondary	\$5,000-\$15,000	Fair	6.8	78
Chen	2000	China	3000	20-90	M/F	Farmer/Factory Worker	Primary/High School	\$2,000-\$8,000	Fair	6.0	73
Lee	2005	Australia	1500	19-75	M/F	Healthcare/Service	University	\$25,000-\$40,000	Excellent	8.5	82
Kim	2010	South Korea	4000	17-85	M/F	Student/Worker	High School/University	\$15,000-\$25,000	Good	7.8	79
Nguyen	2015	Vietnam	2500	18-70	M/F	Teacher/Manager	University	\$10,000-\$20,000	Good	7.2	76
Patel	2018	India	6000	15-90	M/F	Unemployed/Retired	Primary/Secondary	\$3,000-\$10,000	Fair	6.5	74
Wong	2020	Singapore	1200	20-80	M/F	Healthcare/Service	University	\$30,000-\$50,000	Excellent	8.8	84
Alvarez	2022	Spain	3500	19-75	M/F	Student/Worker	University	\$18,000-\$28,000	Good	7.6	81
Costa	2023	Italy	2800	20-80	M/F	Teacher/Manager	University	\$22,000-\$35,000	Very Good	8.1	80
Ng	2024	Malaysia	4500	18-70	M/F	Unemployed/Retired	Primary/Secondary	\$8,000-\$18,000	Fair	6.9	77
Okunaka	2025	Japan	5500	16-85	M/F	Healthcare/Service	University	\$28,000-\$45,000	Excellent	8.6	83
Abdullah	2026	Indonesia	7000	17-90	M/F	Student/Worker	High School/University	\$4,000-\$12,000	Fair	6.7	75
Sharma	2027	Nigeria	3200	18-75	M/F	Unemployed/Retired	Primary/Secondary	\$1,500-\$6,000	Fair	6.3	72
Chen	2028	Taiwan	2200	20-80	M/F	Healthcare/Service	University	\$24,000-\$38,000	Very Good	8.3	81
Almeida	2029	Brazil	6500	16-90	M/F	Unemployed/Retired	Primary/Secondary	\$2,500-\$9,000	Fair	6.6	74
Kim	2030	South Korea	4200	17-85	M/F	Healthcare/Service	University	\$26,000-\$42,000	Excellent	8.7	83
Nguyen	2031	Vietnam	2700	18-70	M/F	Teacher/Manager	University	\$11,000-\$21,000	Good	7.3	76
Patel	2032	India	5800	15-90	M/F	Unemployed/Retired	Primary/Secondary	\$3,500-\$11,000	Fair	6.4	73
Wong	2033	Singapore	1100	20-80	M/F	Healthcare/Service	University	\$31,000-\$51,000	Excellent	8.9	85
Alvarez	2034	Spain	3400	19-75	M/F	Student/Worker	University	\$19,000-\$29,000	Good	7.7	82
Costa	2035	Italy	2900	20-80	M/F	Teacher/Manager	University	\$23,000-\$36,000	Very Good	8.2	81
Ng	2036	Malaysia	4400	18-70	M/F	Unemployed/Retired	Primary/Secondary	\$9,000-\$19,000	Fair	7.0	78
Okunaka	2037	Japan	5400	16-85	M/F	Healthcare/Service	University	\$29,000-\$46,000	Excellent	8.7	84
Abdullah	2038	Indonesia	6800	17-90	M/F	Student/Worker	High School/University	\$4,500-\$13,000	Fair	6.8	76
Sharma	2039	Nigeria	3100	18-75	M/F	Unemployed/Retired	Primary/Secondary	\$1,800-\$7,000	Fair	6.2	71
Chen	2040	Taiwan	2100	20-80	M/F	Healthcare/Service	University	\$25,000-\$40,000	Very Good	8.4	82
Almeida	2041	Brazil	6300	16-90	M/F	Unemployed/Retired	Primary/Secondary	\$3,000-\$10,000	Fair	6.5	74
Kim	2042	South Korea	4100	17-85	M/F	Healthcare/Service	University	\$27,000-\$43,000	Excellent	8.8	84
Nguyen	2043	Vietnam	2600	18-70	M/F	Teacher/Manager	University	\$12,000-\$22,000	Good	7.4	77
Patel	2044	India	5600	15-90	M/F	Unemployed/Retired	Primary/Secondary	\$4,000-\$12,000	Fair	6.7	75
Wong	2045	Singapore	1000	20-80	M/F	Healthcare/Service	University	\$32,000-\$52,000	Excellent	9.0	86

FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
202-408-4000

ABSTRACT OF THE DISCLOSURE

A carcass structure for a vehicle wheel tyre includes at least one carcass ply comprising thread elements substantially disposed transversely of a circumferential extension of the carcass structure, and at least one pair of annular reinforcing structures disposed close to respective inner circumferential edges of the at least one carcass ply. Each of the annular reinforcing structures includes at least one first circumferentially-inextensible annular insert formed of at least one first elongated element extending in concentric coils, and at least one second circumferentially-inextensible annular insert formed of at least one second elongated element extending in concentric coils. The at least one carcass ply has end flaps each turned back around an inner circumferential edge of a respective first annular insert and each axially interposed between respective first and second annular inserts. A method of manufacturing the carcass structure is also disclosed.

LAW OFFICES

FINNEGAN, HENDERSON,
FARABOW, GARRETT,
& DUNNER, L.L.P.
1300 I STREET, N. W.
WASHINGTON, DC 20005
202-408-4000